

Work Order ID 78605

78605

Page 1

January-11-12 2:46:34 PM

Item ID: D3066-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacer
 Start Date: 11/01/2012 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 100.00 ***100*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3066	Rev B

100	FLOW WATER JET	0.00							
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100
 Waterjet **Memo** 0.00 B 12-1-18
 FLOW CNC Waterjet 1-Cut as per Dwg D3066
 6066, 080 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110
 QC **Memo** 0.00 B 12-1-18
 Quality Control

120	QC8- Inspect parts - second check	0.00							
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120
 QC **Memo** 0.00 5/21/19
 Quality Control can't
HUG
2spurs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL***								

106 BR 12-1-24

106X Ø M-12/01/24

12.02.09

106 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

[Handwritten Signature] M.L.J. 12/02/09

M.L.J. 12/02/09
 (106)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

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Parent Item: D3066-1

D3066-1

Parent Item Name: Spacer

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: C02.11.01 Incorporated D3066-1 IPPKJ/RF
IPP Rev:B Now M6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080		Purchased	No			100	sf	301.3000	0.0945	9.947368			
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M6061T6S 080

**

B12-1-18

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT021

301.3

117285

7.3

119009

101.5

119766

192.5

119009

108

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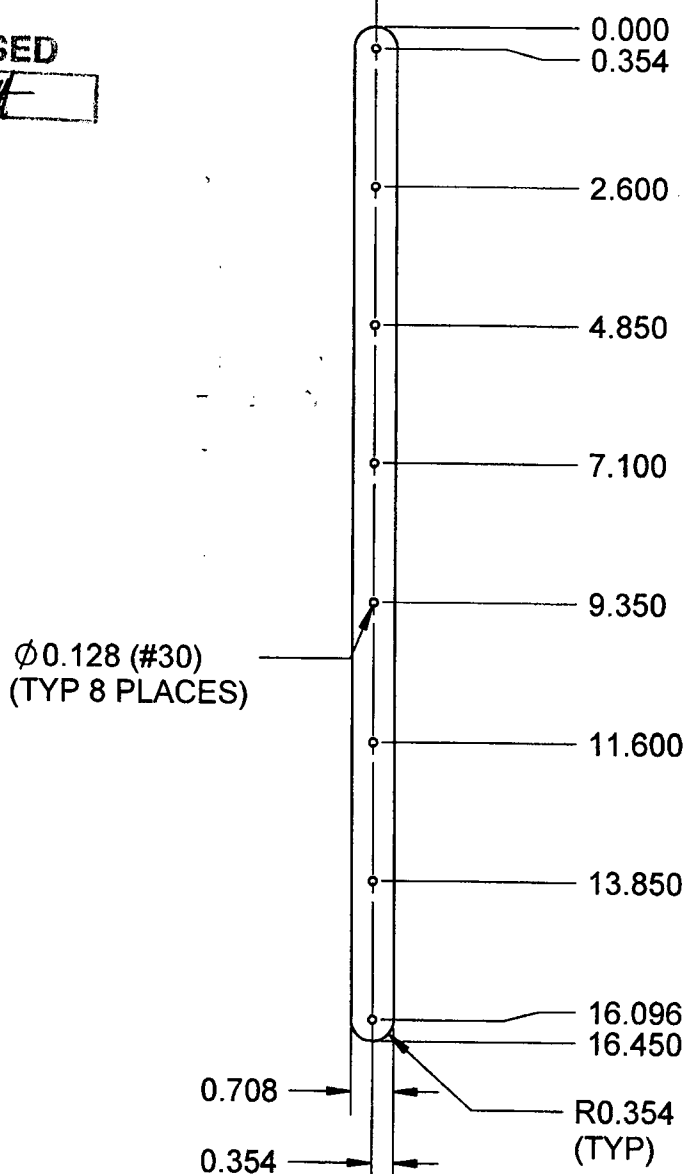
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3066	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED*d.d.w*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38605 M.L.S

12/01/11

D3066-1 SPACER

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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